Quality Control

												DQA:	Date	):
NCR:	Yes	/ No					WORK ORDER NON-	COI	VFOR	MANCE / UP	DATE	OA Classed	Data	
								-				QA Closed:	Date	2.
Nork Ord	er:						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part							Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.						Work Order Update	]		Large Fab	Composite	]	Supplier	
Root					Des	cri	otion of work order update	Π	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		c	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator faterial etup ther rocess upplier raining napproved														
							F	AUI	T CATE	GORY	,			
Land	ng (	Gear	-				General		•			_	_	_
		Bending Centre No Cracks Crushed/0			O/S		Bend BOM/Route Broken/Damaged Burrs		1 '	re on Incomplete ions Incomplete/	'I Inclear	Ovalized Over/Under Part Incorre Part Lost/M	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Cuffs Heat Trea					Contamination Countersink		Mainte Mislabe	nance	Oncical	Part Moved Positioned		
	F	Inspection Ripples in	n Strip in	Tube		-	Cut Too Short Drill Holes	F	Misread Offset		E	Power Loss,		Other
		Torque W		extrusio	า		Drawing		4	Calibration		-		
	Г	Turning S	equence				Finish		Out of S	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 93926 \*93926\* Page 2 November-27-12 3:05:10 PM Item ID: D4434-047 Accept \*N900040100\* Setup Start **Revision ID:** Stop Item Name: Cover Assembly Start Oty: 1.00 **Start Date:** 11/27/12 **Cust Item ID: Req'd Qty:** 1.00 Required Date: 12/07/12 **Customer:** Reference: Run Start Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ **Tooling:** Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ **Tool ID** Reject Reject Insp. Operation Set Up/ Tool # Plan Accept **Work Center ID** Qty Qty Number Stamp Description **Run Hours** Code 120 QC8- Inspect parts - second check 0.00 \*120\* 0.00 QC Memo Quality Control Bend as per dwg 0.00 130 \*130\* Brake NC 0.00 Memo Brake NC 140 0.00 \*140\* Small Fab 0.00

Memo

Transfer drill hole as per dwg

¶ ,

Small Fab

DQA:	Date:	

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

	•									QA Closed:	Da	te:	
Work Orde	r·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	1	Water Jet d. Eng. Coor.		Engineering Quality
NCR N	0			· · · · · · · · · · · · · · · · · · ·	Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	-	Other
Root				Descri	ption of work order update	In	itial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							11						
		<u>.                                    </u>	L			AULT	CATE	GORY	· · · · · · · · · · · · · · · · · · ·	1	<u> </u>	i	
Landin	g Gear				General								
  -  -  -  -  -  -  -	Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in	Crimped. It n Strip in		D/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		nstruct	on Incomplete ions Incomplete/ enance led	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		ressure/Forced emperature/Cure /eld /rong Stock Pulied ther
ŀ	Torque W		xtrusio	, H	Drawing			Calibration					
<u> </u>	Turning S				Finish	<del></del>		Sequence					
T	Wave/Tw	•	e		Folio	-		Dimensions					

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<b>Work Orde</b> November-27-12				*939	26*			_			Page 3
Revision ID:	D4434-047 Cover Assemble	lv		Accept	*N900	<b>040</b>	100	<b>)</b> *	Setup Sta	17	IS1* IS2*
	11/27/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				'`	1. 1/
Approvals:		n:		Tooling:  SPC (Y/N):		nte:	- 	1	Run Sta Sto		JR1* JR2*
Sequence ID/ Work Center II 150 *150* QC Quality Control	D	Operation Description QC5- Inspect part comp Memo	leteness to step on W/O	Set Up/ Run Hourss 0.00 15	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp.
*160 *160* HandFinish Hand Finishing		Chemical Conversion C	oat per QSI005 4.1	0.00	·				H	13.	1·30
170 *170* QC		QC7-Inspect Chemical	Conversion Coat	0.00				1×			\$3 p

Quality Control

			DQA:	Date:
VICD.	Voc / No	MADE ODDED MON CONFORMANCE / LIDDATE		

		,									QA Closed:	Date	:
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part I	No.				····	Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCIVI	10.				<del></del>	work Order opdate	-		raige ran	Composite		Supplier	
Root					Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
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Equip/Tooling	Ш			i									
Operator													
Material	Н												
Setup	-	į	E										
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опаррточеи	<b>.</b>				<u> </u>		ΔΙΙΙΤ	CATE	SORV		1		1
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i	П	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	<del></del>	Weld
		Crushed/0	Crimped.			Burrs		nstruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	_	<b>-</b>
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V	Wrong	_
	$\square$	Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	'Surge	Other
		Ripples in	Bend			Drill Holes		Offset				<u>-</u>	
		Torque W	aves in E	xtrusio	n 🗀	Drawing		Out of 0	Calibration				
		Turning So	equence		[	Finish	$\perp$	Out of 9	Sequence			<del></del>	

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 93926  November-27-12 3:05:10 PM				Page								
Item ID: Revision ID: Item Name:	D4434-047 Cover Assemb	oly	***************************************	Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	171.	S1* S2*
Start Date: Required Date: Reference:	11/27/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:		n:		Tooling:		ate:		]	Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center I 180 *180* Small Fab Small Fab	D	Operation Description  Memo Install rivet	as per dwg	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty		Reject Number	Insp. Stamp
*1 85* QC Quality Control		QC5- Inspect part compl	leteness to step on W/O	0.00					-		·	
186 *186* Powdercoat Powder Coating		Black Sandtex(Ref)4,3 Memo START TIM OVEN TEM FINISH TIM	ME: 9:30 MPERATURE:	0.00 0.00					<u>d</u>	(_B	13	- <u>1-30</u> .

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

									QA Closed:	Date	• •
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		·
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material											
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Process											
Supplier							·				
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[	Bendin	g			Bend	Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped	-		Burrs	Instruct	tions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		<del></del>
	Heat Tr	eat			Countersink	Mislabe	eled		Positioned V	Vrong	
. [	Inspect	ion Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other
Ī	Ripples	in Bend			Drill Holes	Offset		<del></del> -			
	Torque	Waves in I	Extrusio	n	Drawing	Out of	Calibration				
		Sequence			Finish	Out of	Sequence				
ſ	Wave/	wist in Tul	be		Folio	Outside	Dimensions			W *	

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Work Order ID 93926 \*93926\* Page 5 November-27-12 3:05:10 PM \*N900040100\* Setup Start Item ID: D4434-047 Accept **Revision ID:** Stop Item Name: Cover Assembly **Start Date:** 11/27/12 Start Qty: 1.00 **Cust Item ID:** Required Date: 12/07/12 **Req'd Qty:** 1.00 **Customer:** Reference: Run Start Tooling: Process Plan: Date: Approvals: Date: Stop SPC (Y/N): QC: Date: Date: Reject Reject Sequence ID/ **Operation** Set Up/ **Tool ID** Tool # Plan Accept Insp. Number Stamp Qty Work Center ID Description **Run Hours** Code Oty 187 QC3- Inspect Part Finish \*197\* 0.00 13-1.30 QC Memo Quality Control Identify as per dwg & Stock Location 190 0.00 \*190\* 0.00 Packaging Memo Packaging 200 QC21- Final Inspection - Work Order Release 0.00 M13-01-30 0.00 Memo Quality Control

				DQA:_	Date: _	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

					_						QA Closed:	Date:	
Work Orde	er:			· 1		DISPOSITION		· <del>-</del>		AGAINST D	PARTMENT	PROCESS	
	No					Rework Scrap Use-as-is Work Order Update	-	l Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ini	tial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
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Equip/Tooling													
Operator													
Material													
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Supplier													
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Landii						General					<b>-</b> 1		7
	-	Bending				Bend	$\vdash$	rain		L	Ovalized		Pressure/Forced
	_	Centre No	t Concer	ntric to (	<sup>O/S</sup>	BOM/Route	<del></del>	ardwa		<u> </u>	Over/Under	<b></b>	Temperature/Cure
	$\vdash$	Cracks			<u> </u>	Broken/Damaged	<del></del>		on Incomplete		Part Incorred	<b>⊢</b>	Weld
	$\overline{}$	Crushed/C	rimped.		-	Burrs	-		ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
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	$\dashv$	leat Treat		<b>-</b> ,		Countersink	$oldsymbol{oldsymbol{ o}}$	lislabe 		_	Positioned V		<b>7</b> .
		nspection	-	lube		Cut Too Short	<b>⊢</b>	lisread			Power Loss/	Surge	Other
}	$\rightarrow$	Ripples in			_	Drill Holes		ffset					
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	_	Turning Se	•			Finish	_		equence				
		Nave/Twi	st in Tub	e		Folio	1 10	utside	Dimensions				

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## **Picklist Print**

November-27-12 3:05:09 PM

Work Order ID:

93926

Parent Item:

D4434-047

Parent Item Name:

Cover Assembly

**Start Date:** 11/27/12

Required Date: 12/07/12

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP revA 11.10.06 new issue EC verified by:DD

IPP RevB 11.12.22 per PA5

EC verified by:JLM IPP RevC 12.01.24 PER DWG REV.A DD VERF:EC IPP RevD 12.03.05 per REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	146.4578	0.5789	0.609368	4 	12-18	ner mesk sin
				Location MAT021	099	Loc Qty 146.4578 146.4578	<u>Lo</u>	c Code	123	<b>9</b> 74	(*)		,
MS20470AD4-3 Rivet - Universal Head		Purchased	No			185	Each	5,129.0000	•	2	Se	3/0/	/30
				<b>Location</b>		Loc Qty	Lo	c Code				/ /	
				ST336 164 219		564 564 4565			2	)			

Page 1

DQA:	Date:	

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed:	Dat	e:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N	lo				Rework Scrap Use-as-is Work Order Update	Th	Ma ermot	id-tube chining forming rge Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	al	Ac	ction	Sign &	•	
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Desc	cription	Date	Verification	n QC Inspector
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Landin	ng Gear				General						•	
	Bending				Bend	Gra	iin			Ovalized	[	Pressure/Forced
	Centre N	ot Concer	ntric to C	o/s	BOM/Route	Hard	dware			Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection	Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Inst	ruction	ns Incomplete/	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	intena	nce		Part Moved		
	Heat Trea	at			Countersink	Misl	labeled	i		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Miss	read			Power Loss/	Surge	Other
	Ripples in				Drill Holes	Offs	set					
	Torque W	Vaves in E	xtrusion	1 <u>L</u>	Drawing	Out	of Cali	bration				
	Turning S	equence			Finish	Out	of Seq	uence				
	Wave/Tw	ist in Tub	e		Folio	Out	side Di	mensions				

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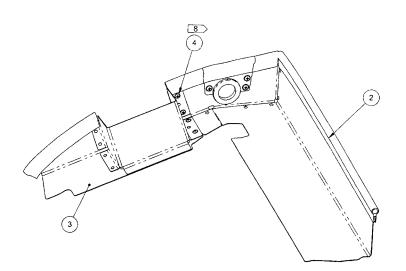
DART AEROSPACE L	TD	Work Order:	92976
Description: Breeket		D - 4 M	7 C p
Description: Bracket		Part Number:	D4434-7
Inspection Dwg: D4434	Rev: 🖟		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.0		L		VBOZ	
1.42	+/-0.030	1,424	7		V	
1.70	+/-0.030	1,698	2		V	
2.24	+/-0.030	2747	2		V	
3.81	+/-0.030	3,807	L		V	
10.41	+/-0.030	10.41	L		T (Ba)	
11.98	+/-0.030	11.48	2		7	
12.52	+/-0.030	17.63	2		7	
12.80	+/-0.030	12-80	2		+	
14.22	+/-0.030	14.22	P_		7	
0.35	+/-0.030	363	2		$\dot{\nu}$	
0.85	+/-0.030	,849	2		V	
1.75	+/-0.030	1,747	Ł		V	
2.65	+/-0.030	2,653	L		U	
2.95	+/-0.030	2 949	<b>L</b>		V	
5.53	+/-0.030	5.63	2	-	1/	
5.82	+/-0.030	5.817	2		V	
6.13	+/-0.030	6,137	2		1/	
5.02	+/-0.030	8.02	2		V	
5.36	+/-0.030	5,361	L		IV T	
5.64	+/-0.030	5,641	2		1/	
2.34	+/-0.030	2.346	L		1,	
2.65	+/-0.030	2.654	V		l V	
3.02	+/-0.030	3,02(	1	<del></del>	V	
11.24	+/-0.030	11.24	1		7	
11.59	+/-0.030	1159	2		7	
11.94	+/-0.030	11.94		, <u></u>	1	
0.040	+/-0.010	, ८३%	25		7	
			DAS			
easured by:	B	Audited by:	15		Preliminary Ap	pproval:
Date:	12-12-18	Date:	ルロド	<b>I</b>		Date:

Rev	Date	Change	Revised by , A	Approved
A	12.02.01	New Issue	KJ 🐼	
			'7)	7

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	х	D4434-041	FWD BRACKET ASSEMBLY
2	1	D4434-043	FWD INBOARD BRACKET ASSEMBLY
3	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



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#### **D4434-041 FWD BRACKET ASSEMBLY**

NOTES:
1) MATÉRIAL: N/A
2) FINISH: N/B
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 1.43 lbs
8) TORQUE SCREW TO 12-15 (in-lb)

8

D

С

DESIG	GN !	RF	DART AFR	CONCE	ITD
REV.	DESCRIPTION			BY	DATE
Α	NEW ISSU	E		RF	12.01.17
В	RE-DESIGN D4434-9/-9F (ZN B5-14, A5-15)			RF	12.02.22

DESIGN	RF		CELTD
DRAWN	RF	HAWKESBURY, ONTARIO,	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	E	D4434	SHEET 1 OF 15
APPROVED	MA	TITLE	SCALE
DE APPR.	-#	COVER ASSEMBLY	NTS

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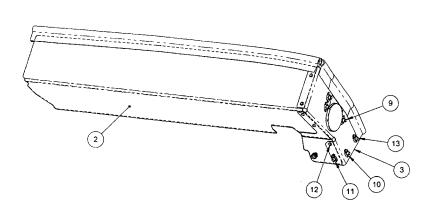
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ITEM	-043	PART NUMBER	DESCRIPTION
1	Х	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-832R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE

(a) (b) (b) (c) (c) (c) (c) (c) (c) (c) (c) (c) (c
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(12)



D4434-043 FWD INBOARD BRACKET ASSEMBLY

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NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

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6) IDENTIFICATION: N/A

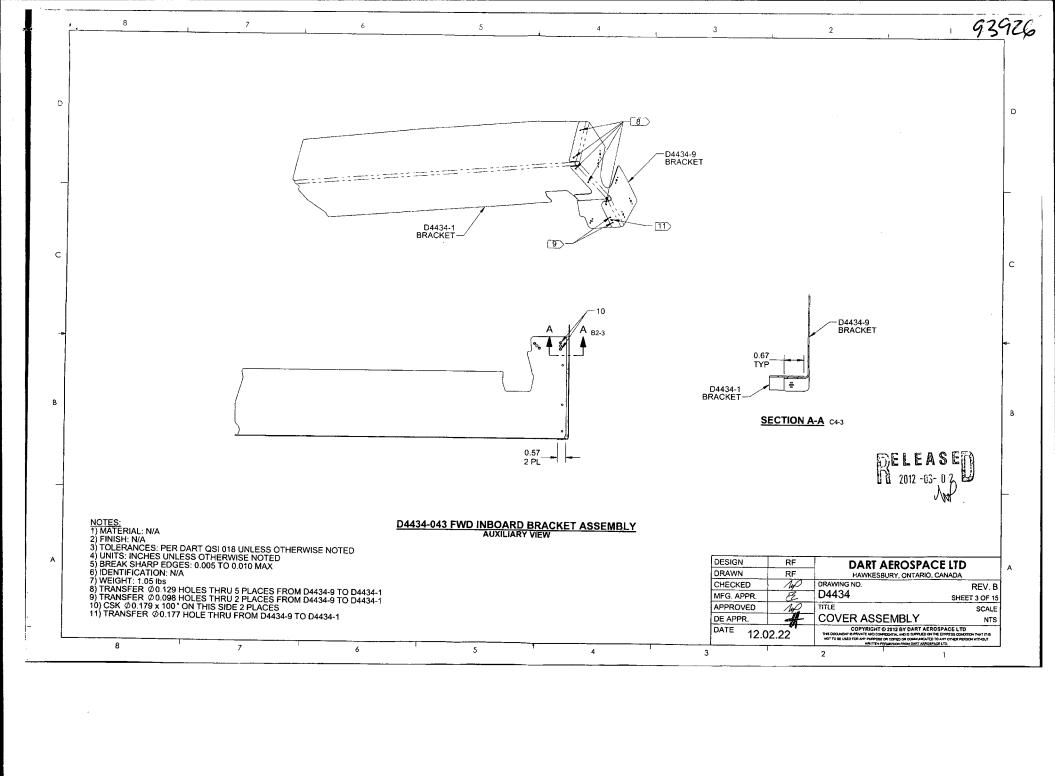
7) WEIGHT: 1.05 lbs

7) WEIGHT: 1.03 IDS 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING 9) TORQUE SCREW TO 12-15 (in-ib)

DESIGN DART AEROSPACE LTD. DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4434 MFG. APPR. SHEET 2 OF 15 APPROVED TITLE SCALE DE APPR. **COVER ASSEMBLY** NTS COPYRIGHT © 2012 BY DART AEROSPACE LTD
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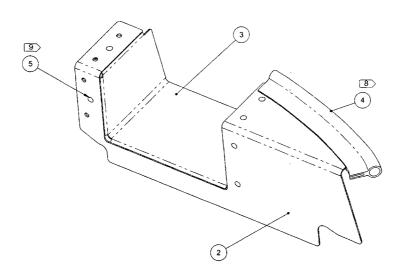
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
2	1	D4434-3	BRACKET
3		D4434-5	BRACKET
4	1	D4441-1-060	RUBBER SEAL
5	6	MS20426AD4-4	RIVET



### **D4434-045 FWD OUTBOARD BRACKET ASSEMBLY**



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NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.365 lbs
8) INISTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
9) TRANSFER Ø 0.129 HOLE 6 PLACES AND CSK TO Ø 0.225 x 100\*

DESIGN	RF	DART AEROSPAC	CE LTD
DRAWN	RF	HAWKESBURY, ONTARIO,	CANADA
CHECKED	Nup	DRAWING NO.	REV. B
MFG. APPR.	E	D4434	SHEET 4 OF 15
APPROVED	NA	TITLE	SCALE
DE APPR.	#	COVER ASSEMBLY	NTS
DATE 12.0	2.22	COPYRIGHT © 2012 BY DART AER	THE EXPRESS CONDITION THAT IT IS

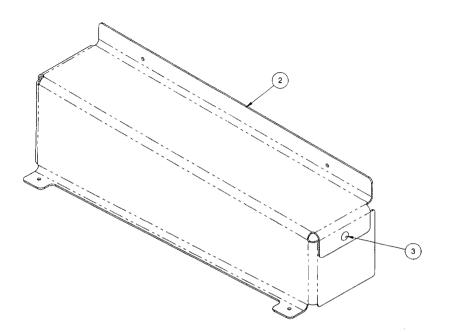
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	ITEM	-047	PART NUMBER	DESCRIPTION	
	1	X	D4434-047	COVER ASSEMBLY	
-	2	1	D4434-7	BRACKET	
	3	2	MS20470AD4-3	RIVET	



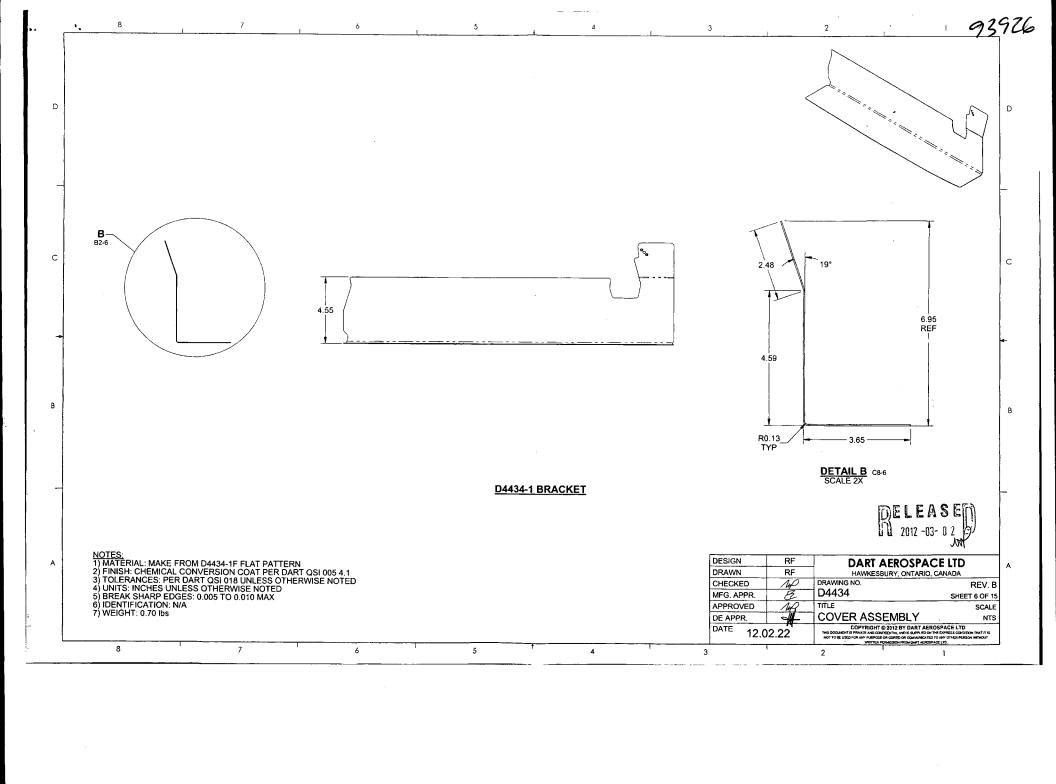
### D4434-047 COVER ASSEMBLY



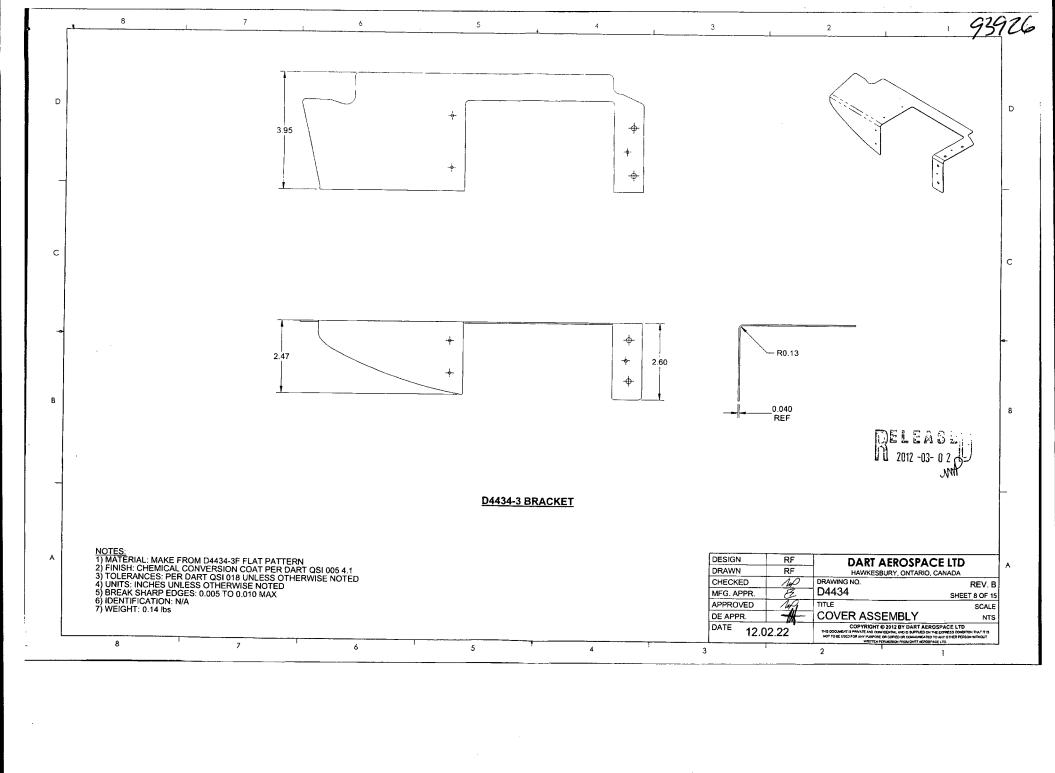
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NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.263 lbs

DESIGN	RF	DART AEROSPACE LTD		
DRAWN RF		HAWKESBURY, ONTARIO, CANADA		
CHECKED	Nep	DRAWING NO.	REV. B	
MFG. APPR.	Z	D4434	SHEET 5 OF 15	
APPROVED	Ne S	TITLE	SCALE	
DE APPR.	#-	COVER ASSEMBLY	NTS	
DATE 12.0	2.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPEDITION AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS		



3 D D R52.7 BEND LINE 10.62 10.26 -- 10.39 Ø0.098 CSK Ø 0.179 x 100°-12 PL R0.45 BEND LINE -7.03 С 0.468 - 6.68 С -- 6.25 GRAIN 4.83 0.67 REF 3.88 DIRECTION 3.23 Ø0.177 - 3.13 2.88 REF R0.50 2.49 - 2.527 0.67 DETAIL C B6-7 0.00 R0.13 \_0.040 REF TYP 0.00 2.22 2.22 2.47 2.72 4.27 4.32 21.68 21.80 22.20 В **D4434-1F FLAT PATTERN** NOTES: 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC. M6061T6S.040 DESIGN RF **DART AEROSPACE LTD** DRAWN RF HAWKESBURY, ONTARIO, CANADA 2) FINISH: NV. 3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.70 lbs DRAWING NO. CHECKED REV. B D4434 MFG. APPR. SHEET 7 OF 15 APPROVED TITLE SCALE COVER ASSEMBLY DE APPR. NTS COPYRIGHT © 2012 BY DART AEROSPACE LTD
THIS COCUMENT IS PRIVATE AND COMPRESTING, AND IS SUPPLIED ON THE EXPRESS CONSTITUTION TO BE USED FOR ANY PLANFOCK OF COPICED OF COLCUMENTED TO ANY OTHER PERSON INSTITUTIONS OF CONTROL DAY ACROSPACILITY. DATE 12.02.22 8 6 5 3



93926 4 D D 10.88 0.45 0.55 1.00 Ø0.098 BEND LINE Ø0.177 6 PL BEND LINE 4 PL R14.2 6.32 5.817 5.59 R1.6 5.118 4.49 -4.53 4.417 С 3.90 С 3.390 3.16 -GRAIN 2.590 DIRECTION R0.25 1.790 0.90 1.00 0.90 0.65 0.40 0.00 0.040 R0.13 REF TYP 6.45 9.70 В 2012 -03- P-2 R0.31 **D4434-3F FLAT PATTERN** NOTES: 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC. M6061T6S.040 DESIGN Α DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA RF DRAWN PEF DART SPEC. M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.14 lbs Ny CHECKED DRAWING NO. REV. B D4434 MFG. APPR. SHEET 9 OF 15 APPROVED TITLE SCALE **COVER ASSEMBLY** DE APPR. NTS COPYRIGHT © 2012 BY DART AEROSPACE LTD
THE DOSLAGHT IS FROM THE CORRESPOND, AND ELEMENTS ON THE EMPERS CONTROL THAT IT IS
NOT TORS USED FOR ANY PURPOSE OF COMEZION COMMAND TO THE OTHER PERSON WITHOUT
MICHITED PERSONS FROM ONIT AEROSPACE LTD. DATE 12.02.22 8 6 5 4 3 2

